

5

**PIGMENTED INK-JET INKS
WITH IMPROVED PRINT QUALITY AND RELIABILITY**

ABSTRACT OF THE DISCLOSURE

10

Compositions, systems, and methods of printing an ink-jet image are provided. The composition can include a liquid vehicle including water, a liquid vehicle having from 5 wt% to 35 wt% of total organic solvent content; from 1 wt% to 6 wt% of acid-functionalized pigment solids; and from 0.001 wt% to 6 wt% of styrene-maleic anhydride copolymer, said styrene-maleic anhydride copolymer having a weight average molecular weight from about 400 Mw to 15,000 Mw.

15

20